

Work Order ID 56763 -2

SPLIT

March 8, 2010 2:19:44 PM



Page 1

Item ID: D2519

Accept



Setup Start



Revision ID:

Item Name: Clamp

Stop



Start Date: 3/08/10

Start Qty: 100.00

92



Cust Item ID:

Required Date: 3/19/10

Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 10/3/19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2519

Rev D

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 11481 Laser cut as per Dwg D2519 Material release note required

GFI

CL

10/3/19

100

110



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure Material Release Note is attached

10/3/19 (92)

120



QC

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Quality Control

(8.561" center to center)

8.561/29

center

x92

03/01/19

Work Order ID 56763

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Page 2

Item ID: D2519

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 3/08/10

Start Qty: 100.00



Cust Item ID:

Required Date: 3/19/10

Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr any rough edges 2-Bend as per Dwg D2519 3-tumble

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

150

0.00



Identify as per dwg & Stock Location: 456

Packaging

Memo

0.00

Packaging

Rec'd 3/25/10

Work Order ID 56763

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Page 3

Item ID: D2519

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 3/08/10

Start Qty: 100.00



Cust Item ID:

Required Date: 3/19/10

Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/31 *[Signature]*

P/10-3-31
(92)

Picklist Print

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Page 1

Work Order ID: 56763

Parent Item: D2519

Parent Item Name: Clamp



Comments: IPP: B 00.03.16 Re-format, laser cutting: EC

Start Date: 3/08/10

Required Date: 3/19/10

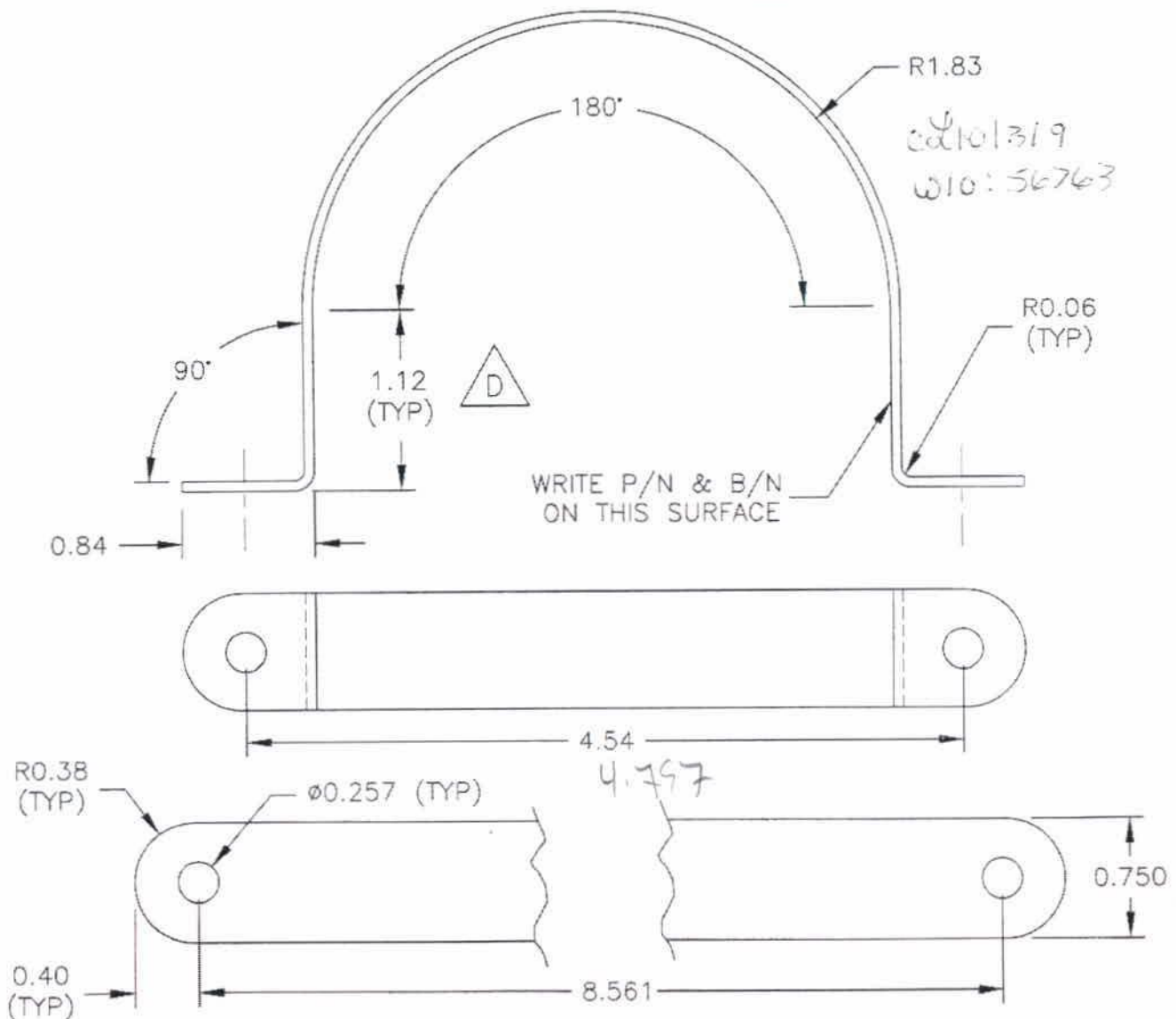
Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2519  Clamp		Purchased	No			120	Each	0.0000	100.0000 		3/14/29	(92)

DART

DESIGN H.F.	DRAWN BY H.F.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H.F.	APPROVED H.F.	DRAWING NO. D2519	REV. D SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

RELEASED
04.11.26**D2519 FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11481

Purchase Order Date 3/09/10

PO Print Date 3/09/10

Page Number 1 of 1

Order From :

VC-GFI001

GFI

180 AVENUE LABROSSE

POINTE CLAIRE, QC H9R 1A1

CA

Contact Name

Vendor Phone

514 630 4877

Vendor Fax

514 630 4849

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2519P	CLAMP	3/23/10 Yes	100.00 Each	Purolator ground	\$10.0000	\$1,000.0

Special Inst: AS PER DWG D2519 REV.D
B56763

NEW 8 NEW 92
P14/3/14 P14/3/14

PO Total:

\$1,000.0

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

FAKED

Change Nbr:

1

Change Date: 3/09/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



180 AVENUE LABROSSE
POINT-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
JR - DY	MO. - MO.	AN. - YR		
24	03	10	0435056	1/1




VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA		
DART	GFI-0299	0211836	PO11481		
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.	DESCRIPTION			
92	D2519F	CLAMP			
CERTIFICATE OF CONFORMANCE REQ					
MFG. JOB# J0211836-001 QTY 92					
 DA					

EXPÉDITEUR
SHIPPER

N° DE BON DE LIVRAISON
SHIPPING MEMO NO.

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.



CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Solr/2

CERTIFICATE NO. 7 OUR JOB NO J0211836 SHIPPING MEMO 0435056

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>-</u>	<u>92 PCS</u>	<u>PO11481</u>	<u>D2519F</u>	<u>D</u>	<u>CLAMP</u>	<u>D</u>
MATERIAL <u>S.S.T 304</u>		SUPPLIED BY <u>SAMUEL & THYSSENKRUPP</u>		MAT. REL. NO. <u>514330 ATT'D</u>		

PROCESS		PROCESSOR	RELEASE NOTE #
1	REF. GFI MANUFACTURING JOB NUMBER J0211836-001 (92 PCS)		
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 25 MARCH 2010

G.F.I. Q.C. REP.

Patricia Hamill





SAMUEL & FILS & CIE (QUEBEC) LTEE.,
2225 AVE. FRANCIS HUGHES,
CHOMEDEY, LAVAL
QUEBEC, H7S 1N5
(514) 384-5220 FAX (450) 669-0633

MTR Retrieval System

GFI, DIVISION DE THOMAS & BETTS LTE Your Purchase Order #: CC05099

Our Work Order #: 009122

Bill of Lading #: 001604298

Print Date: 3/03/2010

The following table relates work-order line-items to heat numbers, grade and size used on the above Purchase Order/Work Order.

WO Line#	Grade	Size	Mill Name	Heat Number/s
1	#2B FINISH	.0620"x48"x96"	THYSSENKRUPP NIROSTA	514330
2	#2B FINISH	.1250"x48"x96"	THYSSENKRUPP NIROSTA	514653
			THYSSENKRUPP NIROSTA	514726
3	DUAL HRAP	.2500"x48"x96"	THYSSENKRUPP NIROSTA	512669
4	#2B FINISH	.1350"x48"x96"	THYSSENKRUPP NIROSTA	511316



Insurance Assurance Qualité Inc. / Assurance Qualité Inc. / Insurance Quality Assurance Inc.
ISO 9001:2000

LETTER OF COMPLIANCE LETTRE DE CONFORMITÉ

GFI Inc.
180 Labrosse
Pointe Claire, Que.
H9R 1A1

DATE: 3/10/2010
votre commande no. CC05099
your order no.

notre commande no. 009122
our order no.

DESCRIPTION

S/S PRIME FEUILLES

Item 1: .0620" x 48" x 96"	Poids	7,300 Lbs.
Item 2: .1250" X 48" X 96"	Poids	8081 Lbs.
Item 3: .2500" x 48" x 96"	Poids	970 Lbs.
item 4: .1350" X 48" X 96"	Poids	175 Lbs.

This is to certify that the material above is within the following specifications
Ceci certifie que le matériel mentionné en rubrique est conforme aux spécifications suivantes:

Item 1: ASTM A240 304/304L
Item 2: ASTM A240 304/304L
Item 3: ASTM A240 304/304L
Item 4: ASTM A240 304/304L

Bien à vous

Yours truly

John Enea
Technicien d'assurance qualité



ThyssenKrupp

ThyssenKrupp Nirosta

Art der Prüfbescheinigung / Type of inspection document / Type du document

ABNAHMEPRUEFZEUGNIS

INSPECTION CERTIFICATE

CERTIFICAT DE RECEPTION

nach / according to / suivant

EN 10204-3.1

Bescheinigungs-Nr. 23.11.2009

Document number

1000159048 /

Seite / Page / Page:

1 / 1

Oberschlesienstrasse 16, 47807 Krefeld

THYSSENKRUPP NIROSTA

NORTH AMERICA INC.

2275 HALF DAY ROAD, SUITE 300

BANNOCKBURN, IL 60015

USA

Besteller/Empfänger / Customer/Consignee / Acheteur/Destinataire

THYSSENKRUPP NIROSTA, BANNOCKBURN,

Kundenbestell-Nr. / Customer's order number / Numéro de la commande du client

51000894 - PO C11413

Verwerkszeug-Nr. / Manufacturer's works order no. / N° de la commande de l'usine productrice

900377291 / 008

Lieferanzugs-Nr. / Delivery Note No. / Avis d'expédition N°

87124890 / 010

Erzeugnis / Product / Produit

BAND/COIL/ROULEAU

Lieferbedingungen / Terms of delivery / Conditions de livraison

ASTM A 240/A 240M

ASME SA 240 Sec.II Part A Ed.07

Schmarke und Gütegruppe / Steel grade and quality / Nuance de l'acier

TYPE 304 L / 304

Kundenmaterial-Nr.
Customer's material number
N° de matière du client

Maße des Erzeugnisses (Dicke / Breite / Länge)
Product dimensions (Thickness / Width / Length)
Dimensions du produit (Epaisseur / Largeur / Longueur)

0.0591 inch x 48.0000 inch

Herstellart
Steelmaking proc.
Mode d'élabor.

AOD

Ausführung
Finish
Fini

IIIc / 2B

Paket-Nr.
Packing-No.
N° Palette

Stückzahl
No of pieces
N° de pièces

Bruttogewicht
Actual weight
Masse effective

Ident-Nr.-Erzeugnis
Ident-No of product
Ident-N° du produit

Schmelzentr.
Cast number
Id. de la coulée

Proben-Id.
Sample Id.
Éprouvette prélevement

Proben-Id.
Sample Id.
Éprouvette prélevement

9942393

1

22.708 lbs

30112

514330

1002182721

1002182722

9942423

1

21.771 lbs

30112

514330

1002182721

1002182722

2

44.479 lbs

Chemische Zusammensetzung / Chemical composition / Composition chimique

Schmelztr. / Cast no.

514330

% C

% Si

% Mn

% P

% S

% Cr

% Ni

% N

0.024

0.41

1.22

0.029

0.0010

18.10

8.02

0.063

Probeninspektion lot
Lot inspection
Éprouvette prélevement

Y80, 2%

Y81, 0

TS

A2*

HV

PSI

PSI

PSI

%

%

1002182721

41189

45540

92530

56.2

164

1002182722

42494

47280

93111

57.4

167

ASTM A 262 02a PRACTICE E I.O.

Beständig gegen Interkrist. Korros./Resistant to intercryst. corros./Résistant à la corros. intercryst.

Maße-Oberfläche/Dimensions-Surface/Dimensions-Surface

Verwechslungsprüfung (Spektralanalyse)/Test of identity/spectrum analysis/Contrôle d'identification (analyse spectrale)

WAERMEBEHANDLUNG: 1050 GRAD C / LUFT

TRAITEMENT TERMIQUE: 1050 GRAD C / AIR

HEAT - TREATMENT: 1050 DEGREE / AIR

FREE OF MERCURY AND RADIO ACTIVE CONTAMINATION

No Ni of Cuban Origin, RoHS - Compliant

NO WELD REPAIR

EN ISO 3651-2 I.O.

I.O.

I.O.

Aussteller der Bescheinigung / Originator of the document / Auteur du document

ThyssenKrupp Nirosta GmbH

Dieses Zeugnis wurde

maschinell erstellt

Werk Krefeld

Abnahme

Butzen

Abnahmebeauftragter

Inspector / Expert

Tel: 02151-832447

Fax: 02151-834106

Stempel des (der) Abnahmebeauftragten
Receiving agent's stamp
Poinçon de l'agent réceptionnaire



Datum der Ausstellung und Bestätigung
Date of issue and validation
date d'émission et validation

23.11.2009

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 304/316 SS SHEET
ANNEALED
2B FINISH

SPECIFICATION: MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240

PART NUMBER: M304S TT GA
GA

WHERE "TT" = GAUGE THICKNESS

EG. 16 GAUGE SS SHEET = M304S16GA

GAUGE THICKNESS REFERENCE:

GAUGE	NOM. THICK. (IN)	THICKNESS RANGE (IN)
26	0.01875	0.0178 - 0.019
25	0.021875	0.0199 - 0.023
24	0.025	0.024 - 0.026
23	0.028125	0.027 - 0.029
22	0.03125	0.030 - 0.032
21	0.034375	0.033 - 0.035
20	0.0375	0.036 - 0.040
19	0.04375	0.041 - 0.046
18	0.050	0.047 - 0.052
17	0.05625	0.053 - 0.058
16	0.0625	0.059 - 0.065
15	0.0703125	0.066 - 0.072
14	0.078125	0.073 - 0.083
13	0.09375	0.084 - 0.098
12	0.109375	0.099 - 0.114
11	0.125	0.115 - 0.130
10	0.140625	0.131 - 0.145
9	0.15625	0.146 - 0.160
8	0.171875	0.161 - 0.176

RELEASED
09/06/23 MB

REFERENCE ONLY

8.0/04/29

B	REFORMAT DWG. ADD ASTM/ASME SPECS (ZN D8-1), ADD GAUGE REF (C8-1), REF PAR D8-520A	CP	09.06.01
A	NEW ISSUE	DS	01.09.24
REV	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. M304S TITLE 304/316 SS SHEET	REV. B	
DRAWN		SHEET 1 OF 1	
CHECKED		SCALE	
MFG. APPR		NTS	
APPROVED			
DE APPR.			
DATE	09.06.01	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDED IN CONFIDENTIALITY AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED FOR CIRCULATION TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries